

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave. St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005853**Date Inspected:** 15-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS tower**Summary of Items Observed:**

Bay #10 South and North Tower Shop

South Tower Lift #2:- Caltrans QA inspector observed four ZPMC welding operators performed semi-automatic SAW on outer corner longitudinal seam weld which connected skin plate C and skin plate D. The weld designed is a double -V-groove with welding conducted in the in flat position (1G). The minimum preheat and maximum interpass temperature requirements for SAW longitudinal seam weld are 110C degree and 230 C degree. The semi-automatic SAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

North Tower Lift #1:- Caltrans QA inspector observed two welders performed FCAW process on the bracket components located at the 9m elevation interior diaphragm. The FCAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

South Tower Lift #1:- Caltrans QA inspector observed three welders performed FCAW process on the bracket components located at the 9m elevation interior diaphragm. The FCAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Bay #11 East and West Tower Shop

West Tower Lift #2:- Caltrans QA Inspector observed four ZPMC welders in process fit up and SMAW tack welding on skin plate E of west tower lift 2. A numerous temporary tack welds have been welded attach to the skin plate E and skin plate A after the skin plate E has been secured. Base on Caltrans observation, no discrepancies were noted.

Summary of Conversations:

As noted within the report above.

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
